



SARTOMER APPLICATION BULLETIN

Ricobonds® and Mold Releases

Molded rubber products containing Ricobond® adhesion promoters require the use of a mold release to prevent mold sticking. While silicone, glycol and other releases do work with the Ricobond® products, their performance is sometimes variable and dependent upon frequent application. PTFE based mold releases usually work the best, but they also may require frequent applications.

Three types of mold releases are effective with Ricobonds®, namely permanent, semi-permanent and non-permanent. Each type has its own advantages and disadvantages. Sartomer Company recommends that you do a simple evaluation to match the best release performance to your specific needs.

Permanent Releases

Permanent or baked on PTFE coatings are certainly the most reliable means of protecting your molds. These coatings are intended for long-term use. The durability of these releases depends upon the characteristics of your compound, for example the durometer, processability, and abrasiveness. Generally permanent releases are recommended as they are both economical and effective. Sartomer Company has worked with two permanent releases both from the following supplier.

Vendor	Telephone	Grades
General Magnaplate	908-862-6200	Electrofluor 604. Nedox MR-3

Semi-Permanent Releases

Semi-permanent PTFE and silicone release coatings often exhibit excellent release properties when used with Ricobonds®. These products are applied to the mold then they are baked onto the mold by running it through a normal heat cycle without a charge. They exhibit variable durability depending upon conditions. Typically they protect a mold for several hours in constant use. Each of the following semi-permanent releases have given satisfactory performance with Ricobonds® in certain production operations.

Vendor	Telephone	Grades
Dwight Products	201-438-337	F203 Bake
Franklynn Industries	800-755-1677	Diamondkote W-2
Miller-Stephenson	203-743-4447	MS-122/2
Stoner	800-227-5538	E430

Non-permanent Releases

Continuous reapplication of non-permanent mold releases is needed for effective use in production. PTFE based non-permanent releases do perform well under certain conditions, but it is recommended that the release be reapplied to with each cycle when using Ricobonds® adhesion promoters.

Vendor	Telephone	Grades
Sherwin Williams	216-566-2000	Sprayon 511,517

Ricobonds® are very easy to work with in both lab and production. If you have any specific questions about the protection of your equipment, please contact our sales office for help and information.

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